

DART SERVICE INSTRUCTION

**TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-667 REV. C AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-667 REV. 2**

REF: CANADIAN STC: SH01-5
REF: FAA STC: SR01304NY

For D206-667-101/-201/-103/-203 or D407-667-105 crosstubes at CHG 003 or later, the D2856-400-694/-773 abrasion strip has been removed, the center D2891-1 or D2892-1 support has been bonded onto the crosstube using Magnabond 6398 and D3595-063-395/-450 Rubber Cushions have been installed underneath the MS21920-20/-22 Clamps. Amend parts list of the IIN-D206-667 Section 5 and ICA-D206-667 Section 32.8 as follows:

REMOVE:

ITEM	QTY -101	QTY -201	QTY -103	QTY -203	QTY -105	PART NUMBER	DESCRIPTION
13	2	2	2		2	D2856-400-694	ABRASION STRIP
14				2		D2856-400-773	ABRASION STRIP


ADD:

ITEM	QTY -101	QTY -201	QTY -103	QTY -203	QTY -105	PART NUMBER	DESCRIPTION
24	4	4	4		4	D3595-063-395	RUBBER CUSHION
25				4		D3595-063-450	RUBBER CUSHION

To prevent the supports from shifting on the D206-667-101/-201/-103/-203 or D407-667-105 crosstubes at CHG 002 or earlier, the D2891-1/D2892-1 supports should be removed and re-installed as follows:

- Follow section 32.1 of ICA-D206-667 for the removal of the crosstubes from the helicopter.
- Remove the qty (2) MS21920-20/-22 clamps from the crosstube that fasten the D2891-1/D2892-1 supports to the crosstube.
- Remove the D2856-400-694/-773 abrasion strip from the crosstube per section 32.5 of ICA-D206-667.
- Inspect the crosstube surface underneath the support for corrosion and mechanical damage per items 5.3.1 and 5.3.2 of the 300 hour inspection of ICA-D206-667. Repair damage within acceptable limits per item 5.3.3 of the 300 hour inspection in ICA-D206-667. Touch up finish per item 5.3.9 of the 300 hour inspection.
- Abrade area to which support will be applied with 400 grit sandpaper. Saturate a clean cloth with MEK or 4105S Wash'n'Wipe Degreaser or equivalent and wipe area until there is no residue.
- Apply a 0.03" to 0.06" thick layer of Magnabond 6398 underneath the D2891-1/D2892-1 support and re-install the support on the crosstube as shown in Figure 1. Position and secure the D2891-1/D2892-1 support on the crosstube using MS21920-20/-22 Clamps. Install a D3595-063-395/-450 Rubber cushion underneath each MS21920-20/-22 Clamp. Torque clamps 80-100 in-lb. Let the D206-667-101/-201/-103/-203 or D412-667-105 crosstube assembly cure as per the Magnabond 6398 instructions before re-installing the crosstube on the aircraft.

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY:	
	D. SHEPHERD (DE # 02)
DATE:	08.11.06
CERT. NO.:	SH01-5
ISSUE NO.:	3

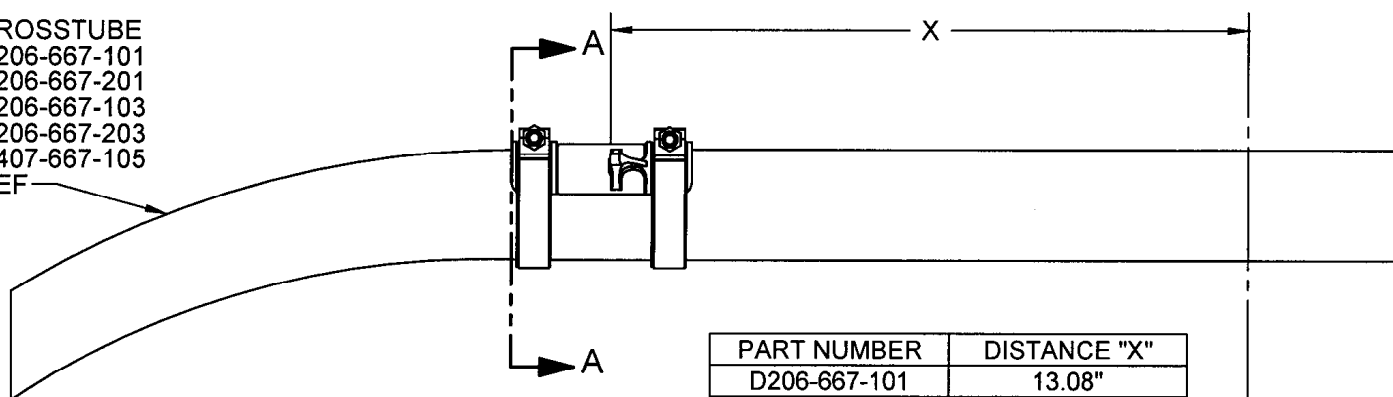
B	D3595-063-395 WAS D3595-075-395; D3595-063-450 WAS D3595-075-450	RF	08.11.06
A	NEW ISSUE	HS	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DS	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9415	SHEET 1 OF 2
APPROVED	DS	TITLE	SCALE
DE APPR.		CROSSTUBE SUPPORT CHANGE	NTS
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7) Re-install the D206-667-101/-201/-103/-203 or D412-667-105 crosstube per section 32.2 of ICA-D206-667.

For customers who would like to upgrade their D206-667-101/-201/-103/-203 or D412-667-105 crosstubes from CHG 002 or earlier to CHG 003, the following kit can be obtained from Dart:

QTY -011	QTY -013	PART NUMBER	DESCRIPTION
X		DSI 9415-011	CROSSTUBE SUPPORT CHANGE (USABLE ON D206-667-101/-201/-103 OR D407-667-105)
	X	DSI 9415-013	CROSSTUBE SUPPORT CHANGE (USABLE ON D206-667-203)
4		D3595-063-395	RUBBER CUSHION
	4	D3595-063-450	RUBBER CUSHION

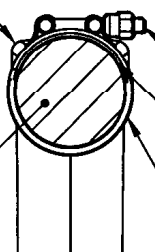
CROSSTUBE
D206-667-101
D206-667-201
D206-667-103
D206-667-203
D407-667-105
REF



PART NUMBER	DISTANCE "X"
D206-667-101	13.08"
D206-667-201	13.08"
D206-667-103	13.08"
D206-667-203	10.03"
D407-667-105	13.08"

D2891-1 OR D2892-1
SUPPORT

CROSSTUBE
D206-667-101
D206-667-201
D206-667-103
D206-667-203
D407-667-105
REF



MS21920-20/22
CLAMP

MAGNABOND 6398 BETWEEN D2891-1/D2892-1
SUPPORT AND CROSSTUBE

D3595-063-395/-450 RUBBER CUSHION
(REF) (2 PLACES)

SECTION A-A


FIGURE 1 - CROSSTUBE SUPPORT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 08.11.06
CERT. NO.: SH01-5
ISSUE NO.: 3

DESIGN HS
DRAWN RF
CHECKED DS
MFG. APPR. N/A
APPROVED DS
DE APPR. 

DATE 08.11.06

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

DSI 9415

TITLE

CROSSTUBE SUPPORT CHANGE

REV. B

SHEET 2 OF 2

SCALE

NTS

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